Date: Friday, 9/14/2007 2:01:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: LUG WELDMENT
Job Number	: 34677		
Estimate Number	: 11873		
P.O. Number	:	**Part Number**	: D335315
This Issue	: 9/14/2007 **S.O. No.** :	**Drawing Number**	: D3353 REV.A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: A
Previous Run	: 30455	**Material**	:
Written By	:	**Due Date**	: 9/30/2007 **Qty:** 4 **Um:** Each
Checked & Approved By	: 07.09.17		
Comment	: est rev. A 06.01.14 new issue EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M1010B0750X0200	1010-1025 BAR

Comment: Qty.: 0.2520 f(s)/Unit Total : 1.0080 f(s)
1010-1025 BAR
AISI 1010-1025 Steel bar 2.00" x 0.750" Batch: M15925 J.L 08/03/10

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks 2.870" long J.L 08/03/10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA613 and Dwg D3353

2- Deburr H.A 08/03/29

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE H.A 08/03/29

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK 08.03.29 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LUG WELDMENT

Job Number: 34677 **Part Number:** D335315

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

08.03.31 4x

Comment: PACKAGING RESOURCE #1 W522

7.0	QC21	FINAL INSPECTION/W/O RELEASE

08.04.02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

mf 08-03-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34677
Description: Lock Bracket	Part Number:	D3353-15
Inspection Dwg: D3353 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.747	✓			
1.20	+/-0.030	1.200	✓			
R0.156	+/-0.010	R 0.156	✓			
0.460	+/-0.010	0.4615	✓			
0.80	+/-0.030	0.80	✓			
0.800	+/-0.010	0.800	✓			
2.75	+/-0.010	2.751	✓			
0.950	+/-0.010	0.947	✓			
0.254	+/-0.030	0.253	✓			
1.40	+/-0.030	1.400	✓			
0.334	+/-0.010	0.334	✓			
Ø0.328	+0.006/-0.001	Ø0.3325	✓			
R0.156	+/-0.010	R0.156	✓			

Measured by:	H.A / gnk	Audited by:	DJP	Prototype Approval:	N/A
Date:	08/03/29	Date:	08/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	
B	06.12.08	0.501 & 1.20 deep dimensions removed	KJ/EC	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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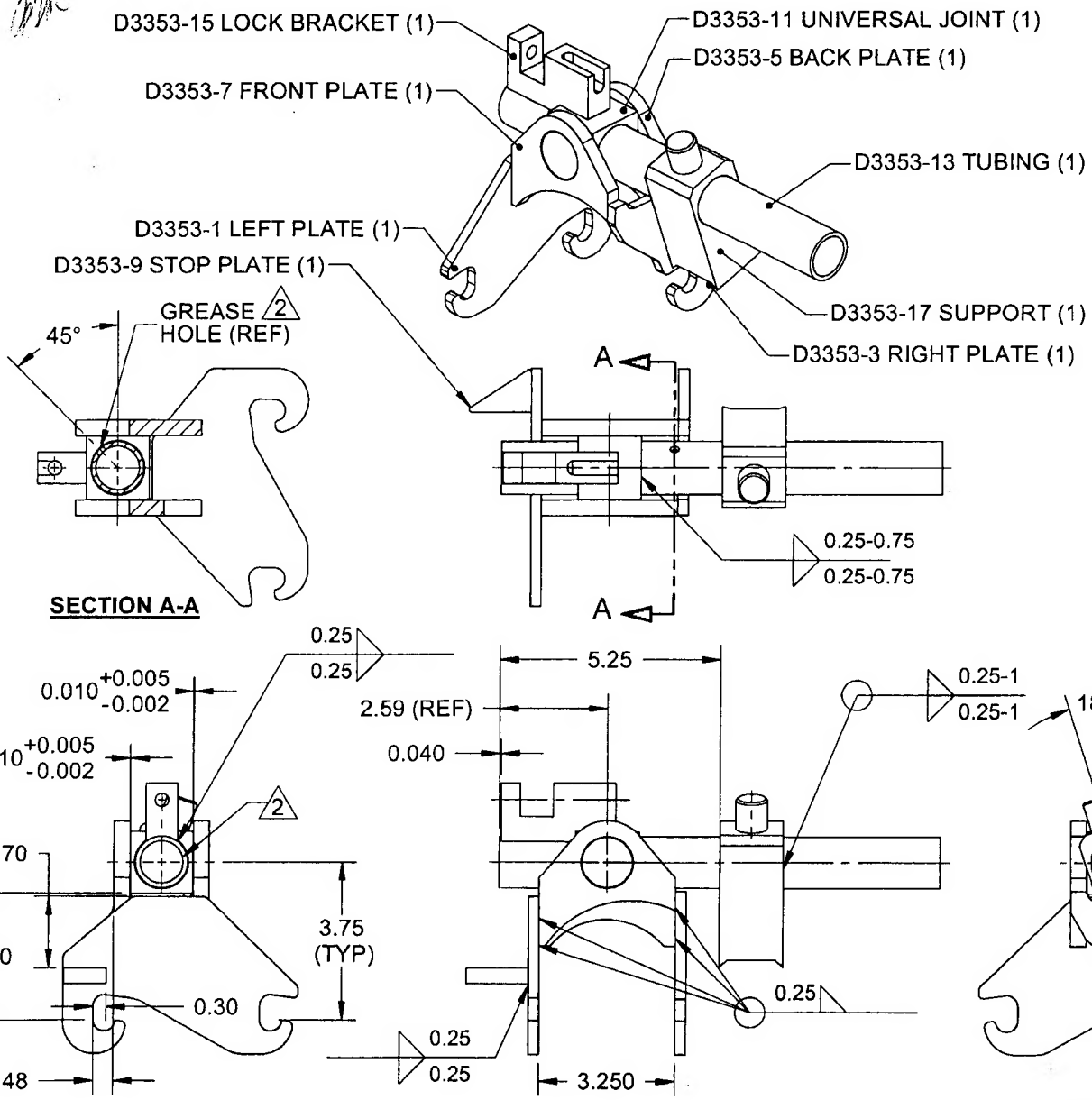
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 1 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED



D3353-041 LUG WELDMENT

NOTES:

1) WELD PER DART QSI 004
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4

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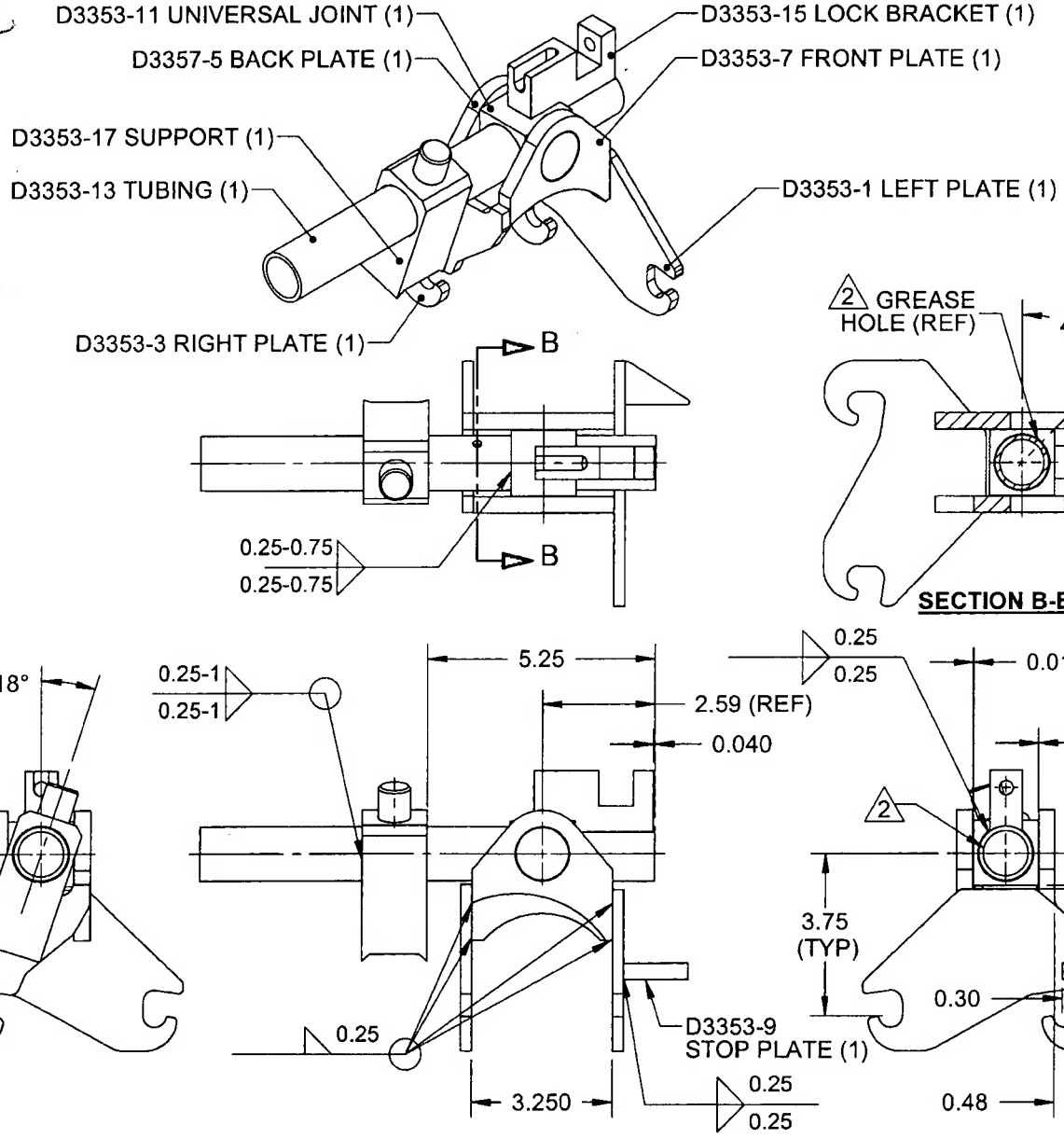
04/03/14



D3353-042 LUG WELDMENT

NOTES:

1) WELD PER DART QSI 004
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:2

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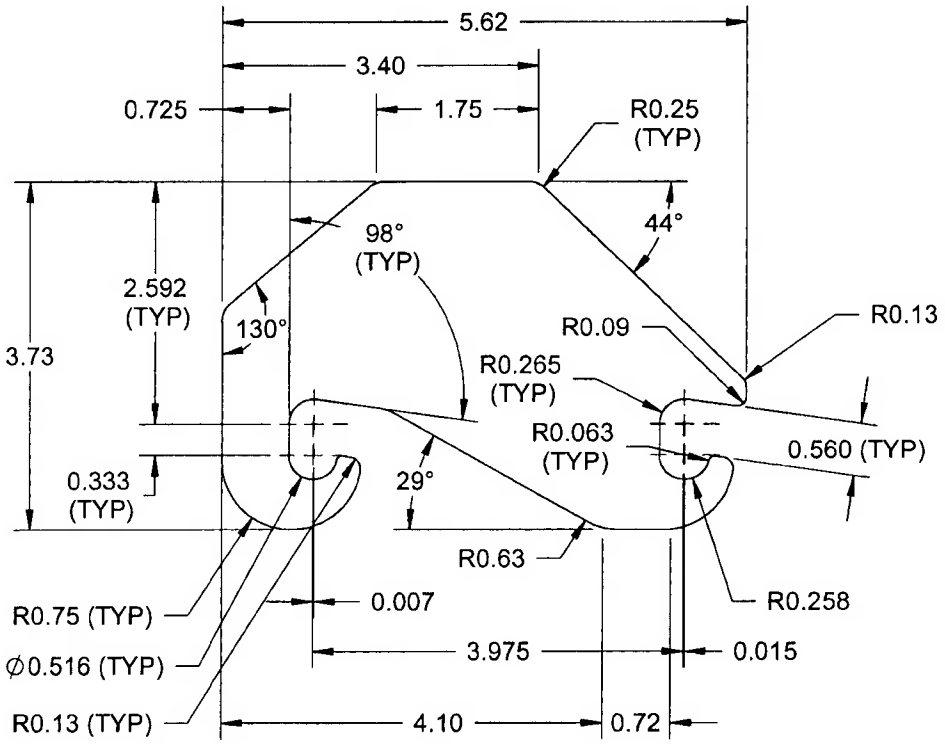
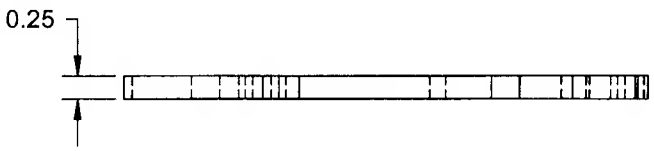
04/07/14





D3353-1 LEFT PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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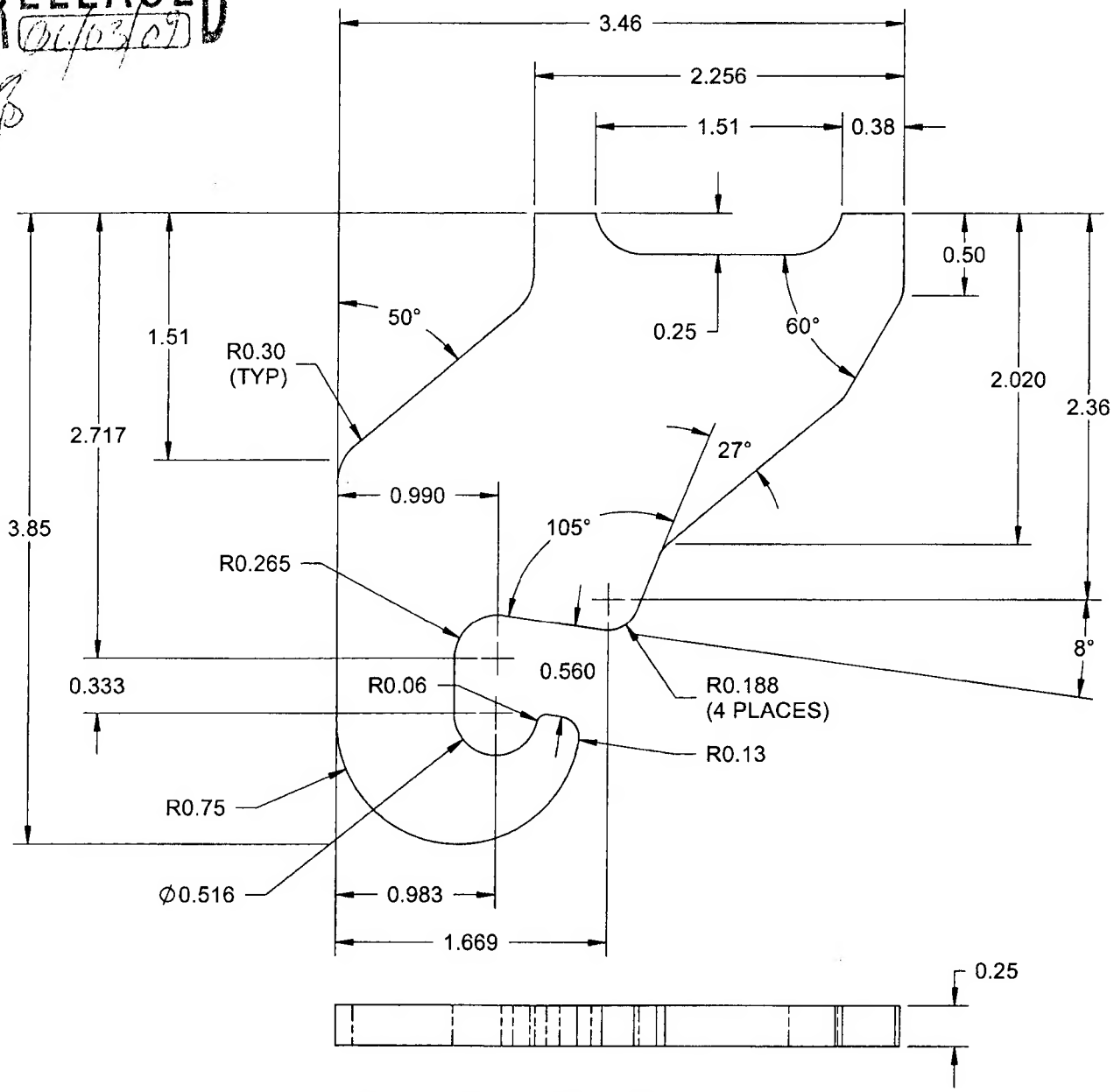
01/03/07



D3353-3 RIGHT PLATE

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NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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		SHEET 5 OF 10
DATE 04.12.14	TITLE LUG WELDMENT	SCALE 1:1

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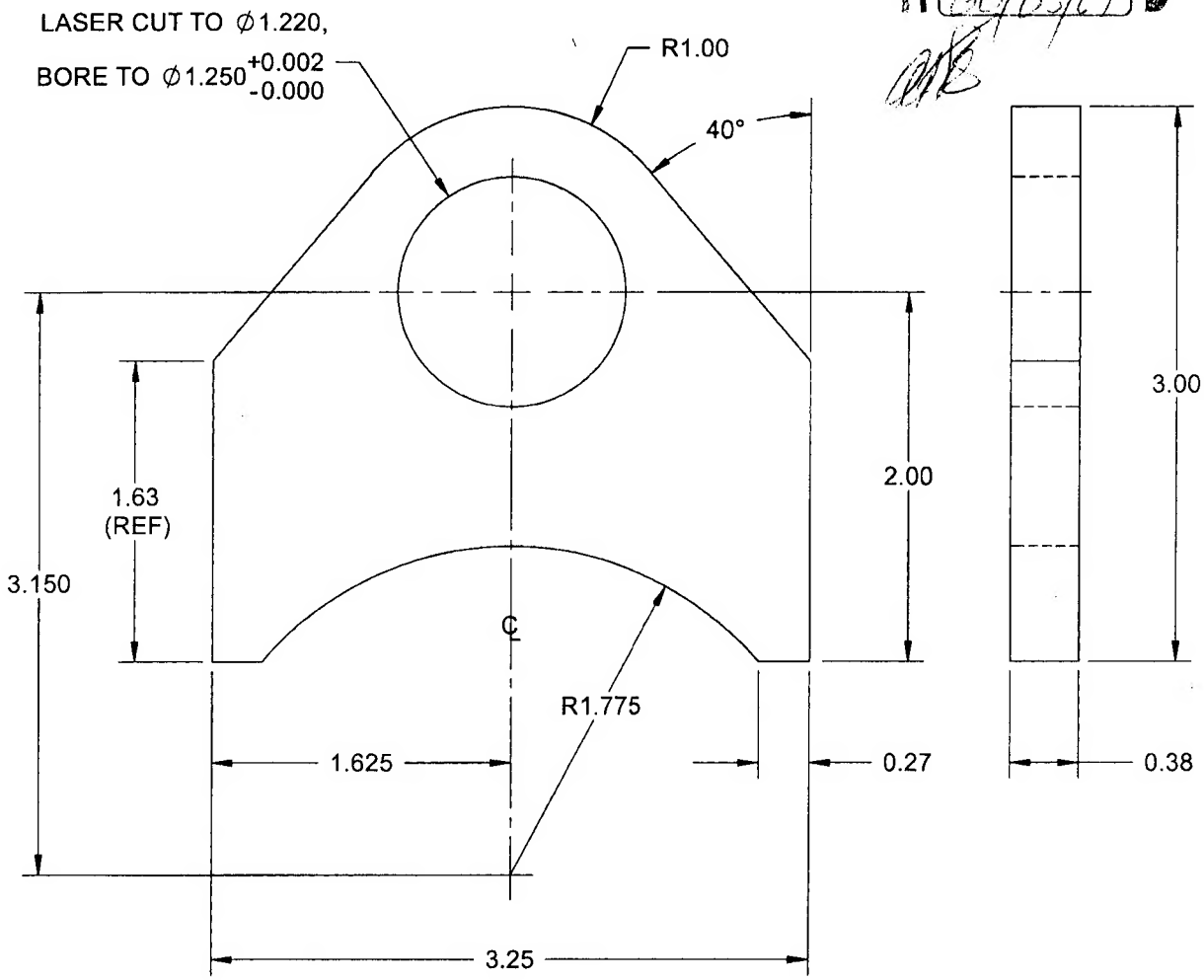

D3353-5 BACK PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
   MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
   MIN. YIELD TENSILE STRENGTH = 28 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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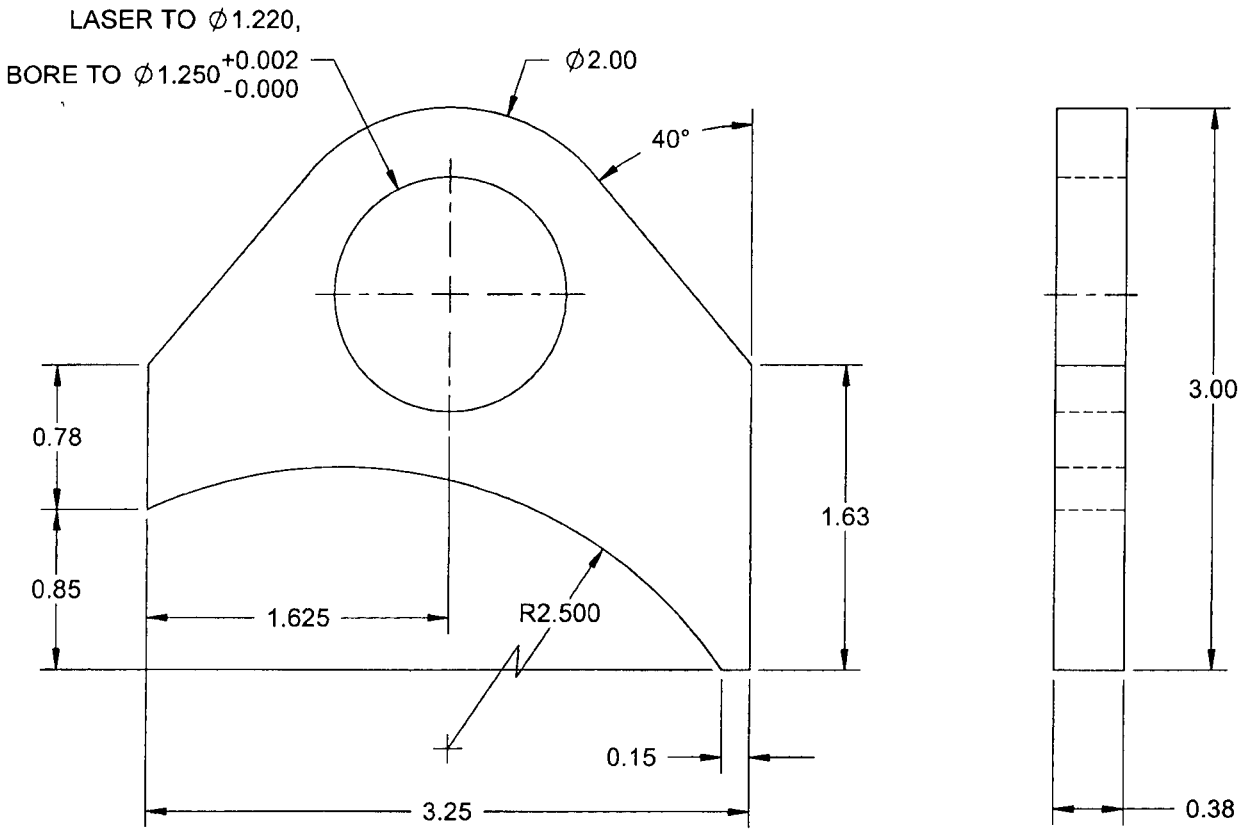

D3353-7 FRONT PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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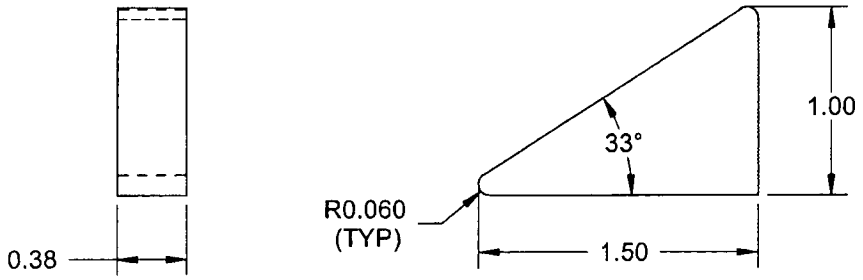
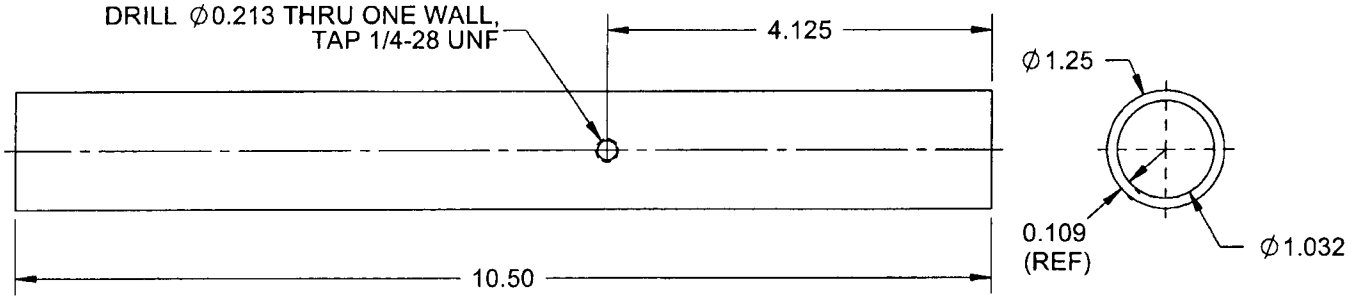


D3353-9 STOP PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING (REF. DART SPEC. M1020TR1.250W.109)

NOTES:

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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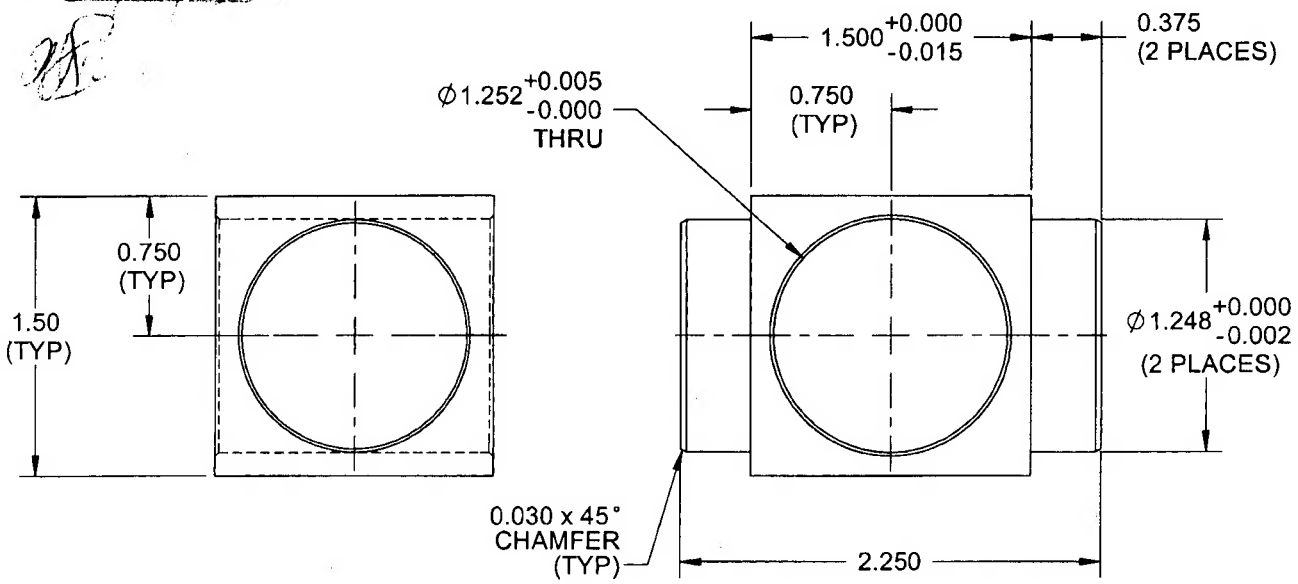
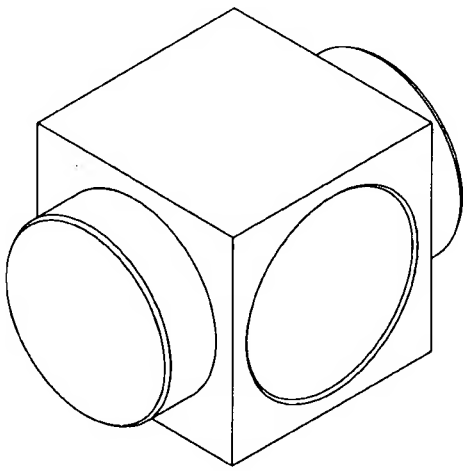
02/3/09





D3353-11 UNIVERSAL JOINT

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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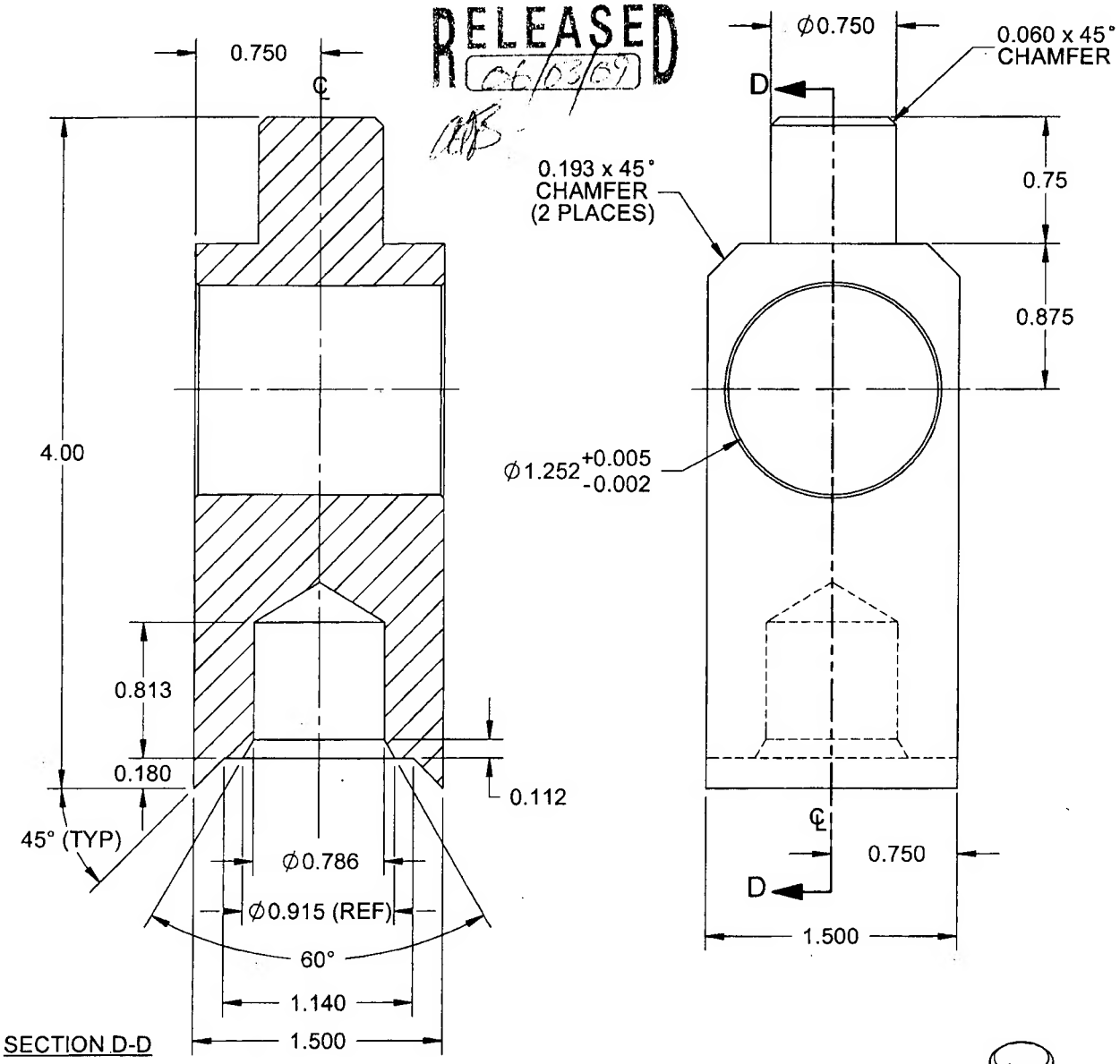
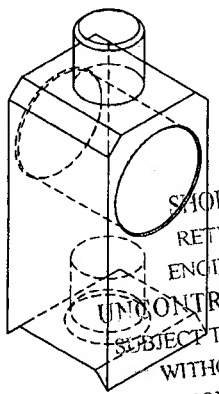
04/03/69



D3353-17 SUPPORT



NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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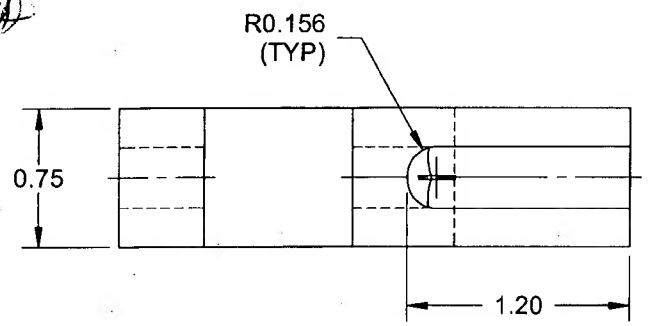
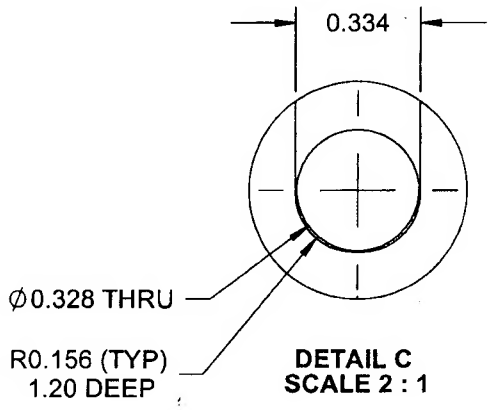
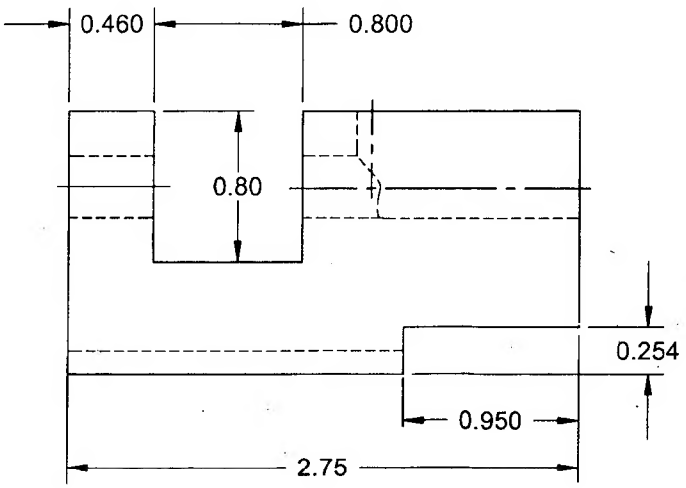
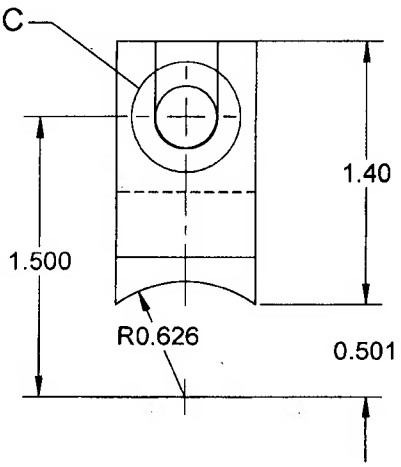
06/03/09





DETAIL C
SCALE 2 : 1

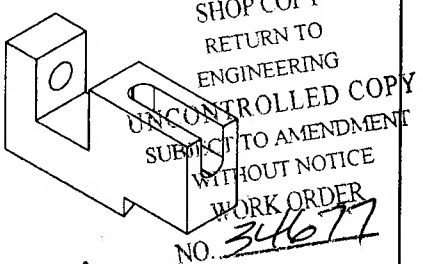




D3353-15 LOCK BRACKET

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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ISOMETRIC VIEW
SCALE 1 : 2

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